

Work Order ID 139907

Monday, December 14, 2015 1:46:34 PM

139907

Page 1

Item ID: D5328-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM **POSITIVE RECALL** Stop ***NS2***
 Item Name: Mesh Base, Fwd
 Start Date: 12/14/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/14/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: DEC 14 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5328	<u>A2</u> <u>201 A</u> <u>5</u> <u>12/14/15</u>								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A2</u> Prog Rev: <u>A2</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control	***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET*** POSITIVE RECALL EFFECTIVE <u>DEC 14 2015</u> AUTH <u>MCS</u> RELEASED _____ DATE _____ <u>RD15-1016-01</u>								
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control	***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET***								

DAS
38
9-89
JAN 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____						

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>PPGL17</u>	0.00							066 36 9-89
130									
Packaging	Memo	0.00							
Packaging	LOCATION: WA006								JAN 12 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MC5 JAN 12 2016

POSITIVE RECALL

EFFECTIVE 15-02-14 AUTH MC5
 LEASED 5 DATE 12/1/09

RD 15-1016-01

Rev A Damm Attached

5.7/6/09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Monday, December 14, 2015 1:46:37 PM

Page 1

Work Order ID: 139907

139907

Parent Item: D5328-5

D5328-5

Parent Item Name: Mesh Base, Fwd

Start Date: 12/14/2015

Required Date: 12/14/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased		No			sf	410.9000		1.336842			

M304FX0 75-16F

Expanded Metal Flat SS

02/16/01/05

Location	Loc Qty	Loc Code
WA004	410.9	
M133198	0.4	
M133466	43.5	
M133763	367	
133868		

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> <th colspan="3" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> <td style="width:15%;">Pressure/Forced ☐</td> <td style="width:15%;">Temperature/Cure ☐</td> <td style="width:15%;">Power Loss/Surge ☐</td> <td style="width:15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="4" rowspan="2" style="text-align: center; vertical-align: top;"> OTHER : _____ </td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </tbody> </table>						Root Cause			FAULT CATEGORY			Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				Misidentified ☐	Past Due ☐
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TRAIL/1901

TRAIL/1901

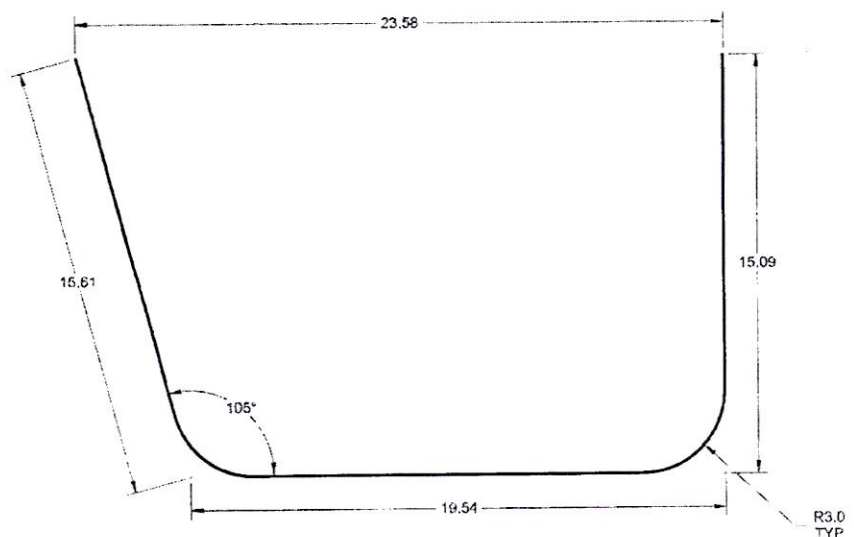
TRAIL/1901

TRAIL/1901

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TRAIL/1901

PRELIMINARY ISSUE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 139907 MLJ

15-12-14

9 D5328-1 MESH, BASE
(REFERENCE)

NOTES:

- 1) MATERIAL: MAKE FROM D5328-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 10.43 lbs APPROX.
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

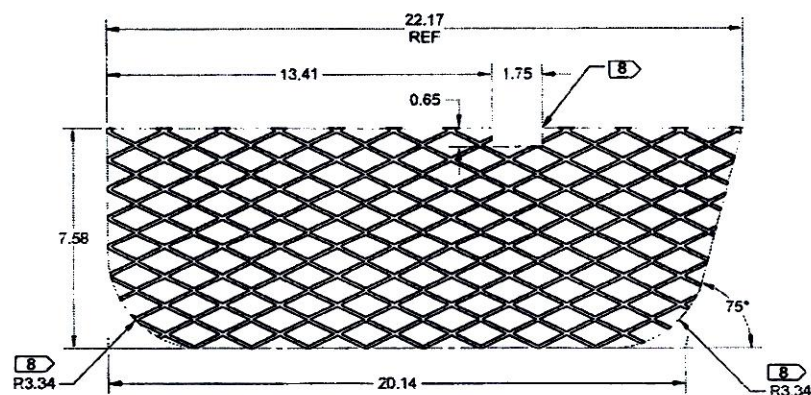
PRELIMINARY ISSUE

A		NEW ISSUE	DESCRIPTION	RF	15.08.10
REV.				BY	DATE
DESIGN		RF			
DRAWN		RF			
CHECKED		AK			
MFG. APPR.		DD			
APPROVED					
DE APPR.					
DATE		15.08.10			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A2
DRAWING NO.	D5328	SHEET 1 OF 4
TITLE	R66/R44 BASKET BASE MESH	SCALE

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REV 1001
1001



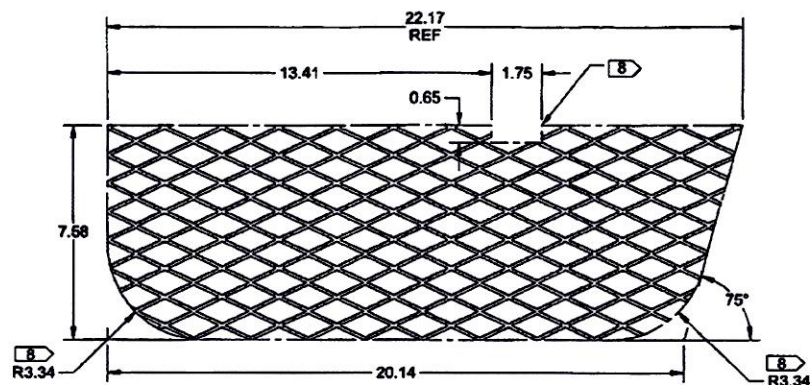
9 D5328-5 MESH END, FWD

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-18F
PER ASTM A240
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.48 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5328	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		R66/R44 BASKET BASE MESH	NTS
DATE	15.08.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD	



8 D5328-5 MESH END, FWD

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PER ASTM A240
REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE

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4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: 0.48 lbs APPROX

8) LOCAL TRIMMING MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE, SEE NEXT ASSY FOR DETAILS

9) TOLERANCE ON XX.XX DIMENSIONS IS ± 0.06 .

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	DD	D5328	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET BASE MESH	
DATE	15.08.10	NTS	

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Monday, December 21, 2015 9:22:54 AM

All amounts are calculated in domestic currency.

Page 1 of 1

All Vendors PO ID PO30733 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-DIV001	Diversified	Ulbrich							
PO30733	1		M304EX0.75-16F	sf	12/21/2015	12/21/2015	640.0000	\$3.86	0.0000	0	\$2,473.17
CAD	No		Expanded Metal Flat SS	sf	640.0000	DCUSER		\$2,473.17	0.0000	0	
			m133868								
	2		71401-45		12/21/2015	12/21/2015	1.0000	\$0.00	0.0000	0	\$0.00
	No		Procurement Quality Clause		1.0000	DCUSER		\$0.00	0.0000	0	
			m133868								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30733**

Purchase Order Date 12/15/2015 8:25:18 AM
PO Print Date 12/15/2015

Page Number 1 of 2

Order From :

VC-DIV001

DIVERSIFIED ULBRICH
20 HYMUS BLV
POINTE-CLAIRE, QC H9R 1C9
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name

Vendor Phone 514 694 6522

Ship To Contact

Ship To Phone

Ship Via: TST Overland

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						

1	M304EX0.75-16F	Expanded Metal Flat SS	12/18/2015		640.00	\$5.16	\$3,302.40
			Yes		sf		
			12/18/2015				

MATERIAL: 304 /316 STAINLESS STEEL EXPANDED METAL
AS PER ASTM F1267 OR MIL-M-17194D
NOTE: DIAMOND MUST RUN ALONG THE 8 FT

Line Total: \$3,302.40

2	71401-45	Procurement Quality Clause	12/18/2015		1.00	\$0.00	\$0.00
			No				
			12/18/2015				

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

Sp 15-12-21

Note:

12/15/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30733**

Purchase Order Date 12/15/2015 8:25:18 AM

PO Print Date 12/15/2015

Page Number 2 of 2

Order From :

VC-DIV001

DIVERSIFIED ULBRICH
20 HYMUS BLV
POINTE-CLAIRE, QC H9R 1C9
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

514 694 6522

Ship To Contact

Ship To Phone

Ship Via:

TST Overland

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$0.00

PO Total: \$3,302.40

Handwritten signature/initials

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 12/15/2015



Diversified Ulbrich
20 Hymus Blvd
PTE. Claire, QC H9R 1C9,
Phone: (514)694-6522 Fax : (514)694-0266
Toll Free: (800)361-5950
SHIP TO:

PACKING LIST

SOLD TO:
00022279
DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

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REPRINT

I094761

SPECIAL INSTRUCTIONS

SHIP TST GROUND COLLECT

Contact: CHANTAL LAVOIE

Ship Terms: COLLECT

MTR:Y

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO
CANADIAN DOLLARS	BOB MESSETT	(613) 632-5200	613) 632-4443	80733

Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W260982	NET 30 DAYS	COMMON CARRIER	12/15/15	12/16/15	12/16/15

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
20	✓	PC	SSH 304 EXP PAPER 16F x 3/4" x 48" 90 LB / 5 PC 270 LB / 15 PC SELLING PRICE @ \$5.16/SQ.FT DIAMONDS MUST RUN ALONG THE 8' LENGTH ***MILL TEST WITH SHIPMENT*** 1 PALLETTE	L046245 L046349	R9T8 R9T8	20 ✓

SP15-12-21

Approx Weight: 360.0 LB 12/15/15 14:18:49

Received by: _____ Date: _____ Signature: _____

P205048

P9T8

006632-



METALLURGICAL TEST REPORT

North American Stainless Canada Inc.
740 Imperial Road North
Guelph, ON N1K1Z3
Canada

740 Imperial Road North

Certificate: 43368 1

Customer: 007040 101

Your Order: P004674

Mail To:

ULBRICH OF CANADA
ULBRICH - TOLLING
C/O NAS CANADA, INC.
740 IMPERIAL ROAD NORTH
GUELPH, ON N1K1Z3

Ship To:

ULBRICH OF CANADA
ULBRICH - TOLLING
C/O NAS CANADA, INC.
740 IMPERIAL ROAD NORTH
GUELPH, ON N1K1Z3

NAS Order: IN 0207915 01

Date: 3/23/2015 Page: 1

Steel: 304/304L

Finish: 2B

Corrosion: ASTM A262/02aE; 180Bend-OK

PRODUCT DESCRIPTION:

STNLS STL COIL, C.R. ANNEALED & PICKLED; UNS 30400/30403
EN10028-2 & EN10088-2, 1.4301/1.4307
ASTM A240/13, A480/13, A666/10; ASME SA240/13, SA480/13, SA666/13
AMS5512H/5513J XMRK; MIL-S-5059D AMD3(X CRN MEAS); MIL-S-4043B
NACE MR0175/ISO 15156-3:2003 A, MR0103/07; QQS766D-A X MAG PERM
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; RoHS 1 & 2 Compliant
Material is Free of Radioactive Contamination
NAS Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant

Product Id	Coil #	Skid #	Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
04R9T8 BA	04R9T8 B		.0590	48.0000	13.860	COIL		1	1

CHEMICAL ANALYSIS

HEAT	CM	C %	CR %	CU %	MN %	MO %	N %	NI %	P %	S %
R9T8	US	.0221	18.0740	.4085	1.7670	.2910	.0734	8.0185	.0315	.0010
SI %										
.2350										

MECHANICAL PROPERTIES

Product Id#	Coil #	1 d o i c r	UTS KSI	20C .2% YS KSI	20C 1% YS KSI	20C ELONG % -2"	Hard RB	Tail Hard
04R9T8 BA	04R9T8 B	F T	90.96	48.68	56.24	52.01	83.50	81.50

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

ABHIJEET BHAVE

4/01/2015

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304H20.15-16F
 DATE: 15-12-21

PO / BATCH NO.: P030733 / M133868

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 640 sq/ft
 QUANTITY INSPECTED: 640 sq/ft
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 16 g.
 THICKNESS RECEIVED: 16 g.
 SHEET SIZE ORDERED: 4' x 3'
 SHEET SIZE RECEIVED: 4' x 8'

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL	(Y)	N	
CORRECT THICKNESS	(Y)	N	
PHOTO REQUIRED	Y	(N)	
CORRECT MATERIAL	(Y)	N	
CORRECT REF # TO LINK CERT	(Y)	N	HT# R9T3
CORRECT MATERIAL IDENTIFICATION	(Y)	N	
CORRECT M# ON THE MATERIAL	(Y)	N	M133868
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	(N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	(N)	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DD</u>	SIGNED OFF BY: _____		
DATE: <u>15-12-21</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

